

Date: Thursday, 23/04/2009 3:32:58 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CHAFING SHIELD		
Job Number	: 47456			Part Number	: D31901		
Estimate Number	: 11138			Drawing Number	: D3190 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 23/04/2009 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 30/04/2009 Qty: 20 Um: Each		
Previous Run	: 40109						
Written By	:						
Checked & Approved By	: JUD 09.04.24						
Comment	: Est. A 03.05.26 New issue KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S25GA	304/316 .020" Sheet	<i>E609/04/27</i>
		Comment: Qty.: 0.2261 sf(s)/Unit Total : 4.5213 sf(s) 304/316 SS .020" Sheet Material: AISI 304/316 SS 0.020" thick sheet (M304S25GA) Batch: M107436	<i>10x</i> <i>10x</i> <i>2x</i> <i>M107513</i>
2.0	SHEAR	SHEAR	<i>E609/04/27(20)</i>
		Comment: SHEAR Cut blank: 9.25" x 3.13" Grind corner as per Dwg D3190 Deburr Roll as per Dwg D3190	
3.0	QC5	INSPECT WORK TO CURRENT STEP	<i>E609/04/27</i> <i>count</i>
		Comment: INSPECT WORK TO CURRENT STEP	<i>S 09/04/27</i> <i>(20)</i>
4.0	PACKAGING 1	PACKAGING RESOURCE #1	<i>E609/04/27</i>
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG	<i>20</i>
5.0	QC21	FINAL INSPECTION/W/O RELEASE	<i>E609/04/27</i> <i>09/04/28</i>
		Comment: FINAL INSPECTION/W/O RELEASE	<i>MF 09-04-28</i>
	Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

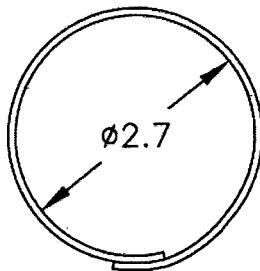
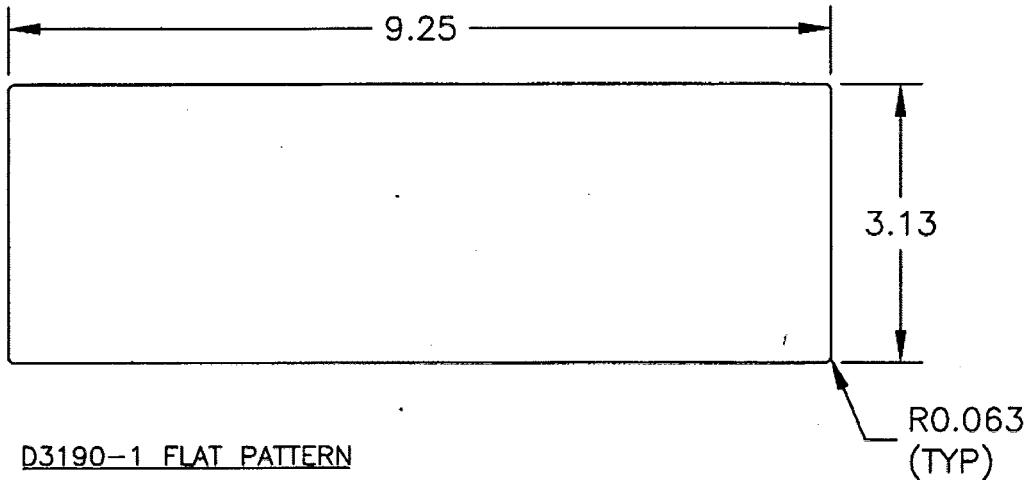
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTCOPY IS
ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3190	SHEET 1 OF 1
DATE	TITLE		SCALE
03.05.16	CHAFING SHIELD		1:2
A	03.05.16	NEW ISSUE	

DRAFTED
03.05.22 AF

D3190-1 ROLLING DETAIL
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 47454